



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4151-1
Job Sheet 200159



Part No: D4151-1

Job Qty: 30 pcs

DAS
21
9-09

Part Name: Lower Hardpoint Plate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/9/19

Job Tracking No:

Due Date: 10/7/19

Type: Stock

Created By: Marie Lajeunesse

Description:

Note: DWG REV C SHEET 2 IPP Rev:A 10.06.24 new issue DD verf:EC IPP Rev:B 11.01.21 as per dwg revC DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	30 pcs	10/7/19	10/7/19	0.00	1.15	Waterjet - Flow		20/01/10
120	QC 8	30 pcs	10/7/19	10/7/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
150	Packaging 3-1 - Stock - B4B	30 pcs	10/7/19	10/7/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		

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					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	DAS
					Packaging 3 - 8 - B4B	28
					Packaging 3 - 9 - B4B	9-89
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	

160	QC 21 - SA	30 pcs	10/7/19	0.00	0.00	QC 21 - SA - 21	
						QC 21 - SA - 70	DAS
						QC 21 - SA - 53	21

Part Op 120 - QC8- Inspect parts - second check)
Descriptions: 150 - (Identify as per dwg & Stock Location: _____)
160 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	1.5240 sf (.0508 ea)	100-Waterjet - Flow - 1	5242860

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S11GA	2	18	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lower Hardpoint Plate	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter	
2	Lower Hardpoint Plate	0.252Inches + 0.003 - 0.000	0.255 0.252	Diameter	
3	Lower Hardpoint Plate	0.375Inches ± 0.010	0.385 0.365		
4	Lower Hardpoint Plate	3.128Inches ± 0.010	3.138 3.118		
5	Lower Hardpoint Plate	1.000Inches ± 0.010	1.010 0.990		
6	Lower Hardpoint Plate	0.500Inches ± 0.030	0.530 0.470		
7	Lower Hardpoint Plate	3.660Inches ± 0.030	3.690 3.630		
8	Lower Hardpoint Plate	2.000Inches ± 0.030	2.030 1.970		
9	Lower Hardpoint Plate	1.000Inches ± 0.003	1.003 0.997		
10	Lower Hardpoint Plate	0.125Inches ± 0.010	0.135 0.115		

Plex 9/9/19 8:45 AM Dart.lajeunesse.marie

NCR No. _____		Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Eng. (Non-AW) ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Finishing ☐ Rec/Store/Packaging ☐ Skid-tube ☐ Machining ☐ Large Fab ☐						Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date :		Sequence #:		QTY Affected :		MRB (QS1042)											
Description Work Order Deviation				Disposition													
														Completed By			
														Lead hand / Supervisor			
														QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY													
				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____				Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			